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D350-636-022
Job Sheet 193667



Part No: D350-636-022

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Standard Wearplates - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/18/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 5/29/19

Type: Stock

Description: SIOP

Note: D2750-052 REV.H, IIN-D350-636 REV.K IPP REV.A 18.11.27 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Skidtubes - 1	1 pcs		5/29/19	0.00	0.00	Skidtubes - 1			
							Skidtubes - 2			
							Skidtubes - 3			
							Skidtubes - 4			
							Skidtubes - 5			
							Skidtubes - 6			BE
							Skidtubes - 7			
110	Skidtubes - 2 - B4B	1 pcs		5/29/19	0.00	4.36	Skidtubes - 1 - B4B			
							Skidtubes - 2 - B4B			
							Skidtubes - 3 - B4B			
							Skidtubes - 4 - B4B			
							Skidtubes - 5 - B4B			BE
							Skidtubes - 6 - B4B			
							Skidtubes - 7 - B4B			
120	QC 10	1 pcs		5/29/19	0.00	0.00	QC 10 - 10			
							QC 10 - 18			
							QC 10 - 24			
							QC 10 - 43			
							QC 10 - 50			
							QC 10 - 58			
							QC 10 - 9			
130	QC 5	1 pcs		5/29/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
140	Handfinish - 1-1 Chemical-B4B	1 pcs		5/29/19	0.00	0.91	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			
							Handfinish - 1 - 4 - B4B			

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H317437RH

S17413715

Fy072

				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR19/04/01
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	1 pcs	5/29/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
160	Skidtubes - 3 - B4B	1 pcs	5/29/19	0.00 4.36	Skidtubes - 1 - B4B
					Skidtubes - 2 - B4B
					Skidtubes - 3 - B4B
					Skidtubes - 4 - B4B
					Skidtubes - 5 - B4B
					Skidtubes - 6 - B4B
					Skidtubes - 7 - B4B
170	QC 10	1 pcs	5/29/19	0.00 0.00	QC 10 - 10
					QC 10 - 18
					QC 10 - 24
					QC 10 - 43
					QC 10 - 50
					QC 10 - 58
					QC 10 - 9
180	QC 5	1	5/29/19	0.00 0.00	QC 5 - 10

	pcs					QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	5/29/19	0.00	0.91	Handfinish - 2 - 1 - B4B		MAY 23 2019 689-89
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
200 Spray Paint - 2 - B4B	1 pcs	5/29/19	0.00	0.69	Spray Paint - 1 - B4B		MAY 21 2019 17-5-24
					Spray Paint - 2 - B4B		
					Spray Paint - 3 - B4B		
					Spray Paint - 4 - B4B		
					Spray Paint - MJ1 - B4B		
					Spray Paint - MJ2 - B4B		
					Spray Paint - MJ3 - B4B		
					Spray Paint - MJ4 - B4B		
202 QC 14	1 pcs	5/29/19	0.00	0.00	QC 14 - 15		MAY 14-5-27
					QC 14 - 2		
					QC 14 - 34		
					QC 14 - 41		
					QC 14 - 51		
					QC 14 - 58		
					QC 14 - 59		
					QC 14 - 9		
					QC 14 - 68		
					QC 14 - 40		
					QC 14 - 19		
230 Handfinish - 4-1-Assembly-B4B	1 pcs	5/29/19	0.00	0.00	Handfinish - 4 - 1 - B4B		MAY 14-6-3
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 - B4B		
					Handfinish - 4 - 15 - B4B		
					Handfinish - 4 - 2 - B4B		
					Handfinish - 4 - 3 - B4B		
					Handfinish - 4 - 4 - B4B		
					Handfinish - 4 - 5 - B4B		
					Handfinish - 4 - 6 - B4B		
					Handfinish - 4 - 7 - B4B		
					Handfinish - 4 - 8 - B4B		
					Handfinish - 4 - 9 - B4B		
240 QC 5	1 pcs	5/29/19	0.00	0.00	QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		

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250	Packaging 1-1 - Pick Kit - B4B	1 pcs	5/29/19	0.00	0.00	QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
260	QC 4	1 pcs	5/29/19	0.00	0.00	Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	PC
						Packaging 1 - 24 - B4B	
						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
270	Packaging 3-1 - Stock - B4B	1 pcs	5/29/19	0.00	0.00	Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
						QC 4 - 28	
						QC 4 - 58	
						QC 4 - 69	JRB
						QC 4 - 9	
						QC 4 - 46	
						QC 4 - 68	
						Packaging 3 - 1 - B4B	JRB
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	

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				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	5/29/19	0.00 0.00	DC - 1 - B4B	DAS 21 JUN 10 2019
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	5/29/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	DAS 21 JUN 10 2019

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 (D2750-6 details). Drill using drill Jig DT8150. 4- Locate Descriptions: DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail BM to 0.297" (total of 2 holes per side) and one 0.201" each side as per dwg 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - 1- Open up holes of Detail BN using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 4- Chamfer holes of Detail BN, ground handling and float holes per dwg D2750 (welding instructions on sheet 16) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5163437 exp. date 09/12/19 ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 38989 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5163577 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5179047

202 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - Assemble as per dwg) 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D2750 SIKAFLEX 241 BATCH: _____ EXP DATE: _____ 5-Coat all exposed fasteners with "LPS Procyon" batch: _____

240 - (QC5- Inspect part completeness to step on W/O)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-012
 275 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-012 CHG 008
 280 - (QC21- Final Inspection - Work Order Release)

010244

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	90-Skidtubes - 1	5166246
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 2 - B4B	192137
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 3 - B4B	5130291
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 3 - B4B	5173407
AN3C5A	Bolt 5156446	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B	5162846
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5174233
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5174233
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167316
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5160325
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5163735
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B	5179461
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5181203
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5191118
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180555
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5176769
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5186226
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5149193
NAS1149C0332R	Washer 5148669	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5158074
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-2
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B	5093556
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167517
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	x 5186014
MS21043-3	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5169772
NAS1149C0363R	Washer	2 Ea (2 ea)	230-Handfinish - 4-1-Assembly-B4B	5079518
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5135100
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149198
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5139509
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5187203
				5166718

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Skidtubes - 1	D2600-3-BENT-RH	1	5	0
110-Skidtubes - 2 - B4B	D2744	1	21	0
160-Skidtubes - 3 - B4B	D2739	1	10	0
	D2743	8	151	0
230-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	38	1,178	0
	AN3C34A	1	12	0
	AN3C5A	34	1,250	0
	AN3C6A	4	218	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-4	1	2	0
	D3537-1	3	38	0
	D3631-1	8	213	0
	D3791-1	1	3	0
	D3793-1	1	5	0
	D3793-3	1	2	0
	D3793-5	1	15	0
	MS21043-3	1	1,074	0
	MS21043-6	4	158	0
	MS21083C8	1	332	0
	NAS1149C0332R	38	3,939	0
	NAS1149C0363R	2	493	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	332	0
	NAS1149D0863J	2	585	0

Part Specifications

Specifications could not be found.

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DAK

AEROSPACE

Spbury, OH 44114

ADA

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Container No: S174187



Part: D350 - 636 - 022

Job No: 193667

Serial No/Batch: S174187

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC SH0064653 10/16/12/10 STC SH99-7 Issue 2, EASA STC

QTY -041	QTY -042	QTY -043	QTY -044	QTY -051	QTY -052	P/N	DESCRIPTION
X						D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X					D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X				D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
				X		D2750-051	350 SKIDTUBE ASSEMBLY, LH
					X	D2750-052	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	1	1	D2739	WEB
8	8	8	8	8	8	D2743	CROSS BOLT SPACER
1	1	1	1	1	1	D2744	CAP
8	8	8	8	8	8	D2745	BUSHING
1						D2750-1	350 SKIDTUBE ASSEMBLY
	1					D2750-2	350 SKIDTUBE ASSEMBLY
		1				D2750-3	350 SKIDTUBE ASSEMBLY
			1			D2750-4	350 SKIDTUBE ASSEMBLY
				1		D2750-5	350 SKIDTUBE ASSEMBLY
					1	D2750-6	350 SKIDTUBE ASSEMBLY
1		1		1		D3488-3	BLADE FITTING, LH
	1		1		1	D3488-4	BLADE FITTING, RH
4	4	4	4			D3490-1	CROSS BOLT SPACER
4	4					D3490-3	CROSS BOLT SPACER
		4	4			D3490-5	CROSS BOLT SPACER
8	8	8	8			D3492-041	PLUG
8	8					D3492-043	PLUG
		8	8			D3492-045	PLUG
3	3	3	3	3	3	D3537-1	WEARPAD
8	8	8	8	8	8	D3631-1	WASHER
1	1	1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	1	1	D3793-5	WEARSHOE
38	38	38	38	38	38	ALS4-1032-225	INSERT
				1	1	AN3C34A	BOLT
34	34	34	34	34	34	AN3C5A	BOLT
4	4	4	4	4	4	AN3C6A	BOLT
4	4	4	4	4	4	AN6C44A	BOLT
1	1	1	1	1	1	AN8C35A	BOLT
				1	1	MS21043-3	NUT
4	4	4	4	4	4	MS21043-6	NUT
1	1	1	1	1	1	MS21083C8	NUT
38	38	38	38	38	38	NAS1149C0332R	WASHER
				2	2	NAS1149C0363R	WASHER
1	1	1	1	1	1	NAS1149C0832R	WASHER
4	4	4	4	4	4	NAS1515H3L	WASHER

NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4/-5/-6 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.1 lbs
D2750-051/-052 = 25.7 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 19/64" SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

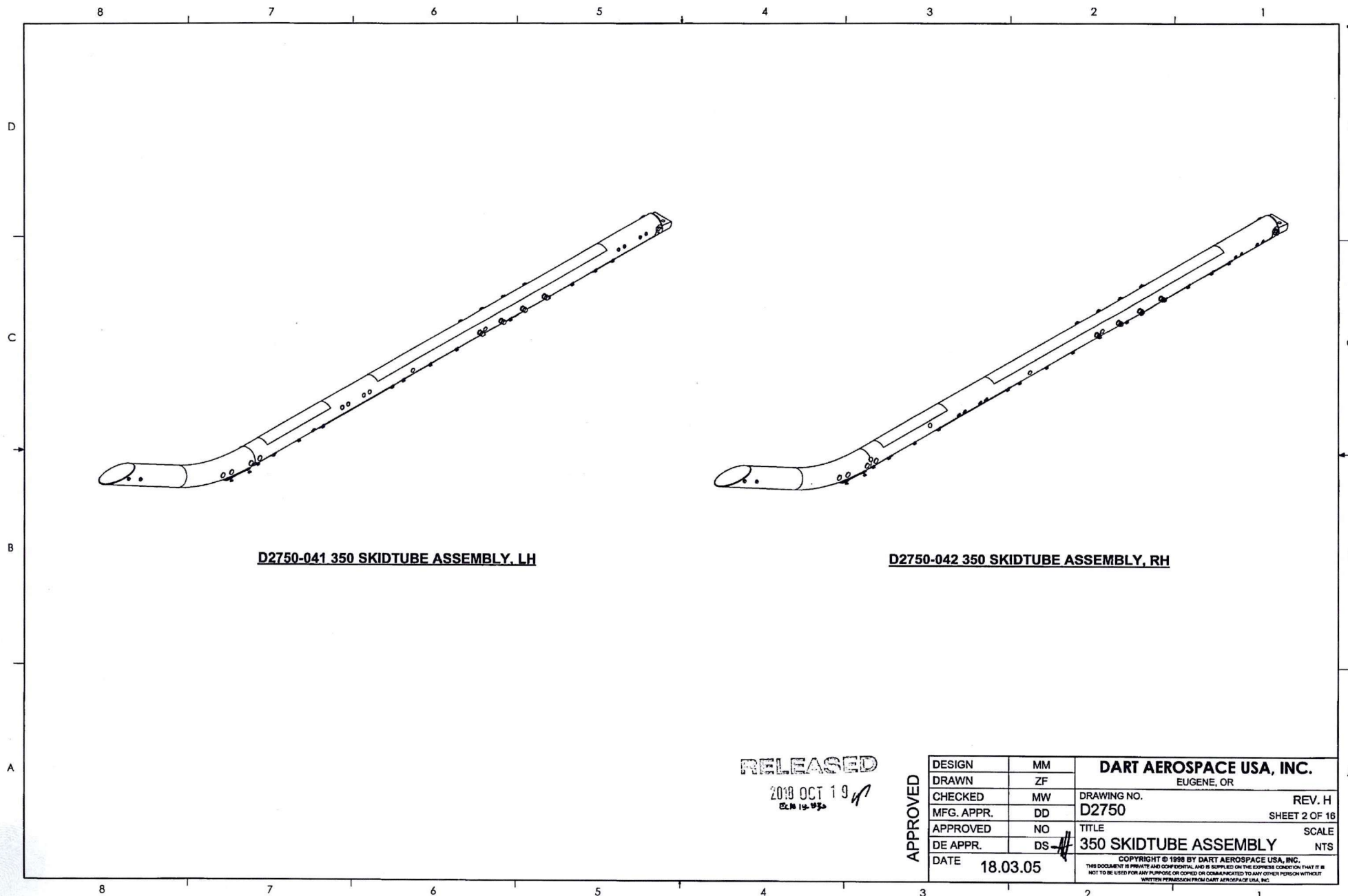
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H	ADDED -051/-052 (ZN D5-1 SHEETS 4, 15-16); ADDED D2750-5/-6 (ZN C5-1 SHEETS 9, 10); D3488-3/-4 REPLACES D3488-041/-042 (ZN C5-1, D2-11/-12/-13/-14); D3793-5 REPLACES D3535-25 (ZN B8-1, C4-11/-12/-13/-14); NAS1149C0332R REPLACES AN980C10L (ZN A5-1, B1-11/-12/-13/-14, C7-11/-12/-13/-14); NAS1149C0832R REPLACES AN980C816L (ZN A5-1, C1-11/-12/-13/-14); REMOVED D3794-1/-3, AND D3536-25 GASKETS	ZF	18.03.05
G	CORRECTED TOLERANCE ON ϕ 0.500 THRU HOLE: IS +0.01/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL TWO BEND ORIENTATION (ZN D-1/-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AST SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN980C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S283 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.	DD	D2750	SHEET 1 OF 16
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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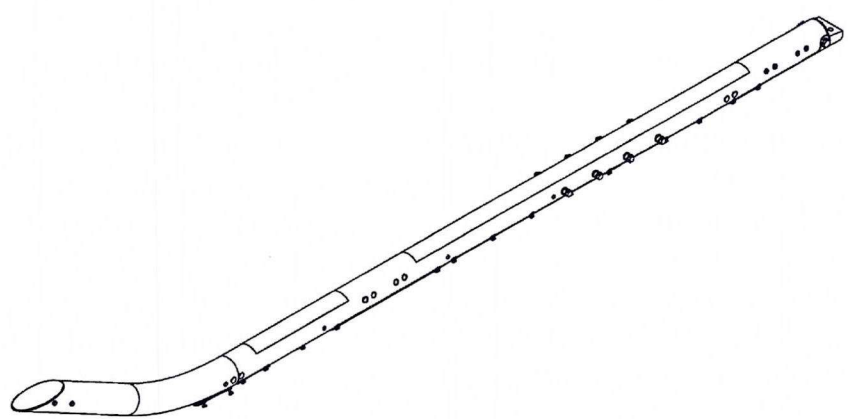
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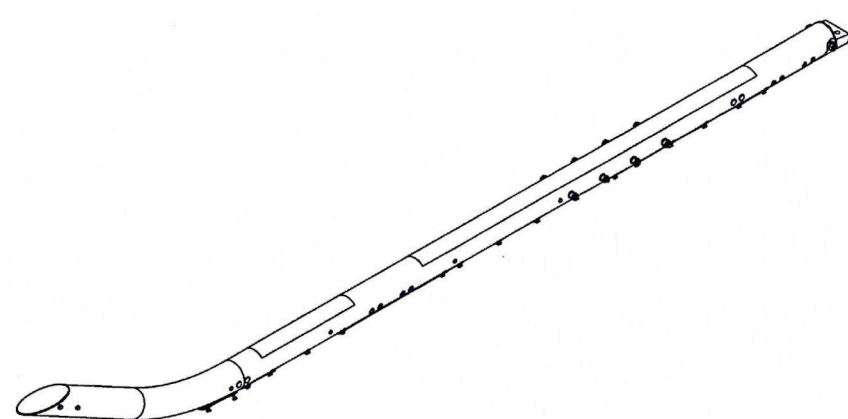
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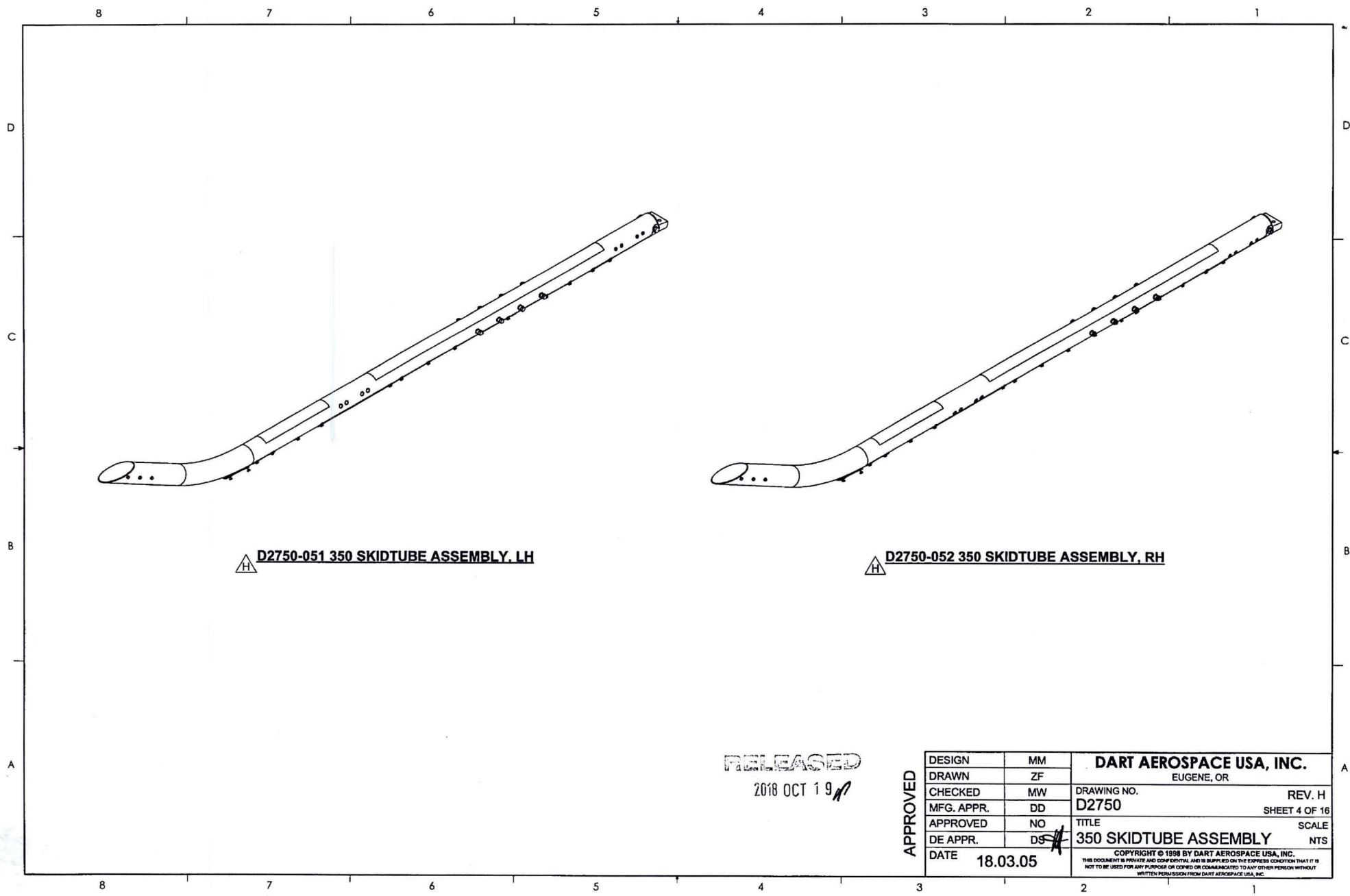
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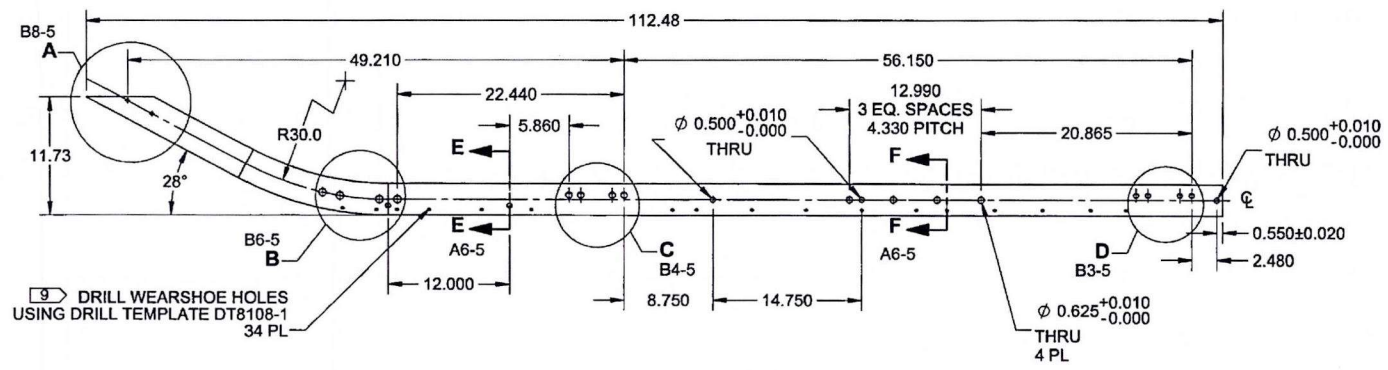
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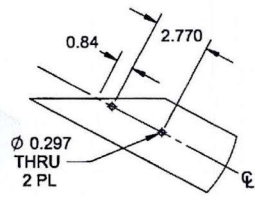
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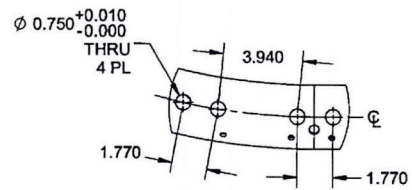
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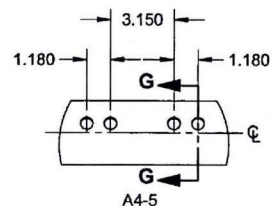
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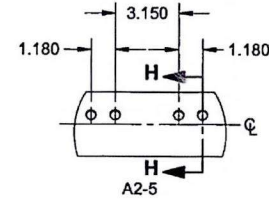
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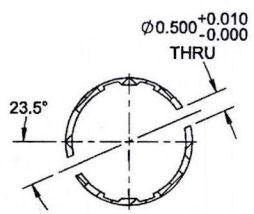
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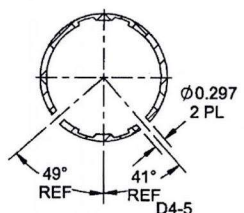
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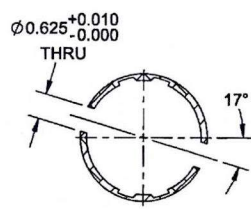
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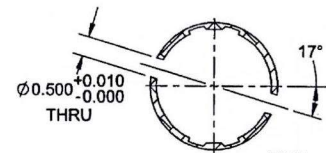
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SECTION F-F
SCALE 4X, 17 PL



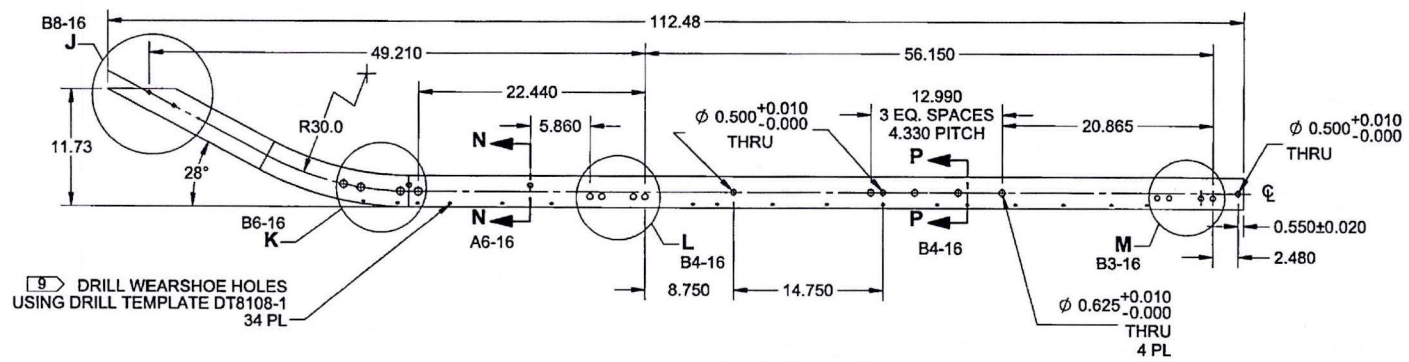
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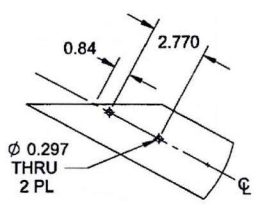
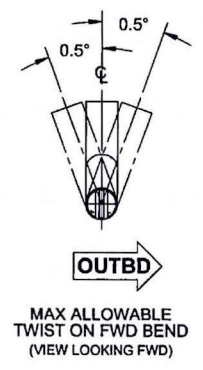
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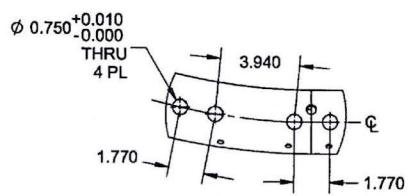
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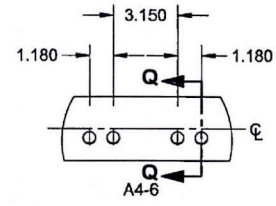
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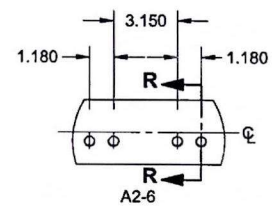
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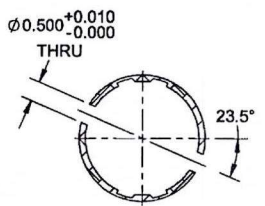
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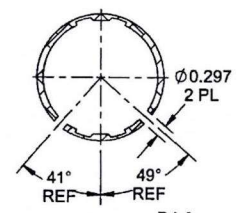
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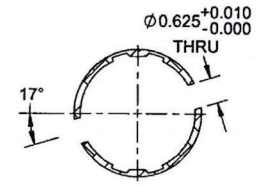
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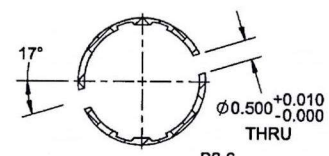
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D6-6



SECTION P-P
SCALE 4X, 17 PL
D4-6



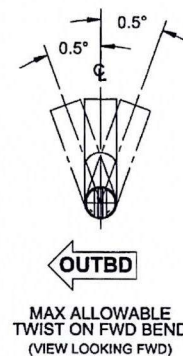
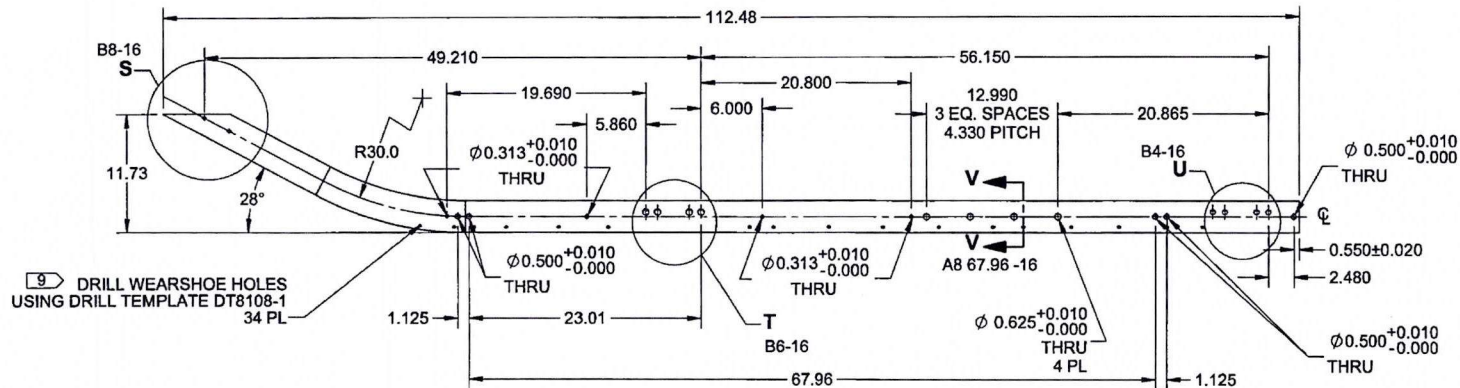
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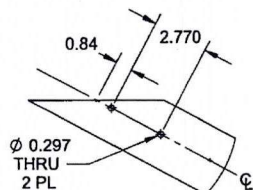
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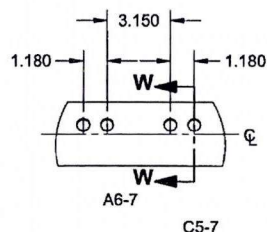
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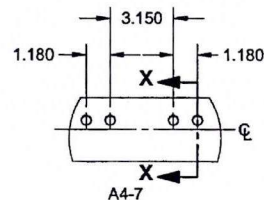
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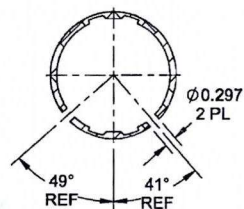
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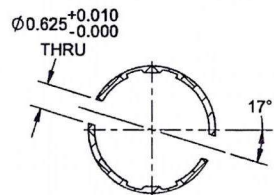
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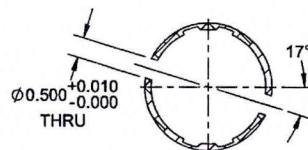
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SECTION V-V
SCALE 4X, 17 PL



SECTION W-W
SCALE 4X, 4 PL



SECTION X-X
SCALE 4X, 4 PL

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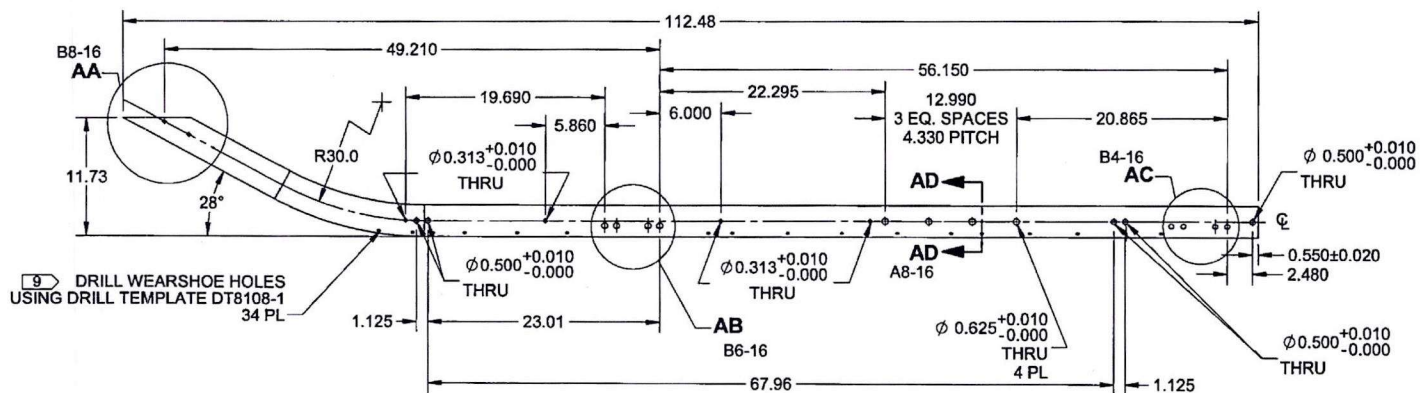
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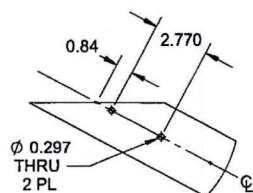
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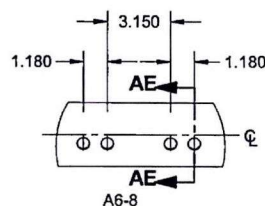
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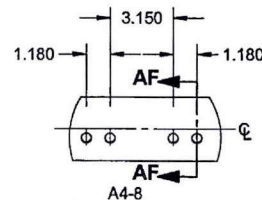
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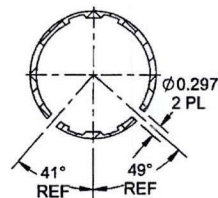
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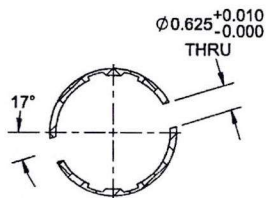
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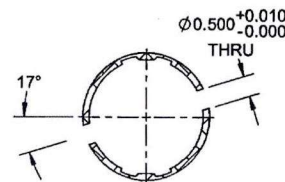
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SECTION AD-AD
SCALE 4X, 17 PL



SECTION AE-AE
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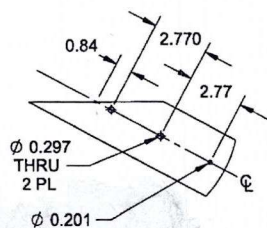
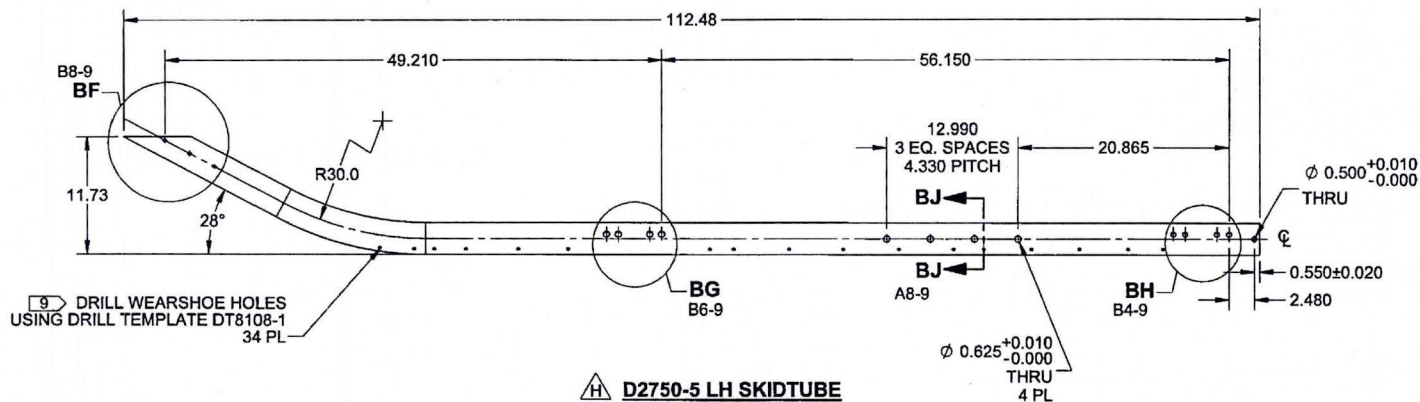


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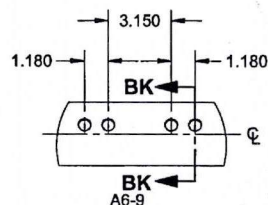
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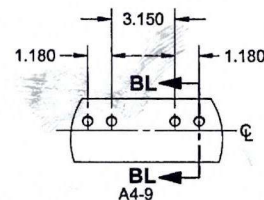
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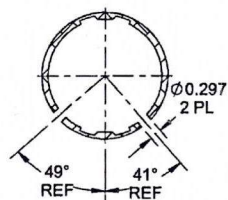
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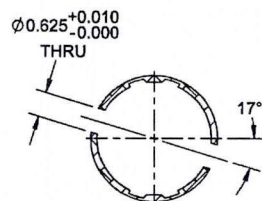
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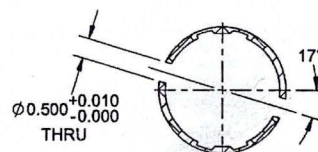
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SECTION BJ-BJ
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SECTION BK-BK
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SECTION BL-BL
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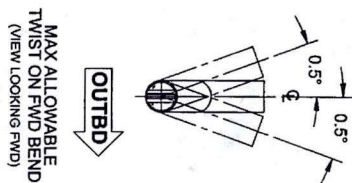
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D2750	SHEET 9 OF 16
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS

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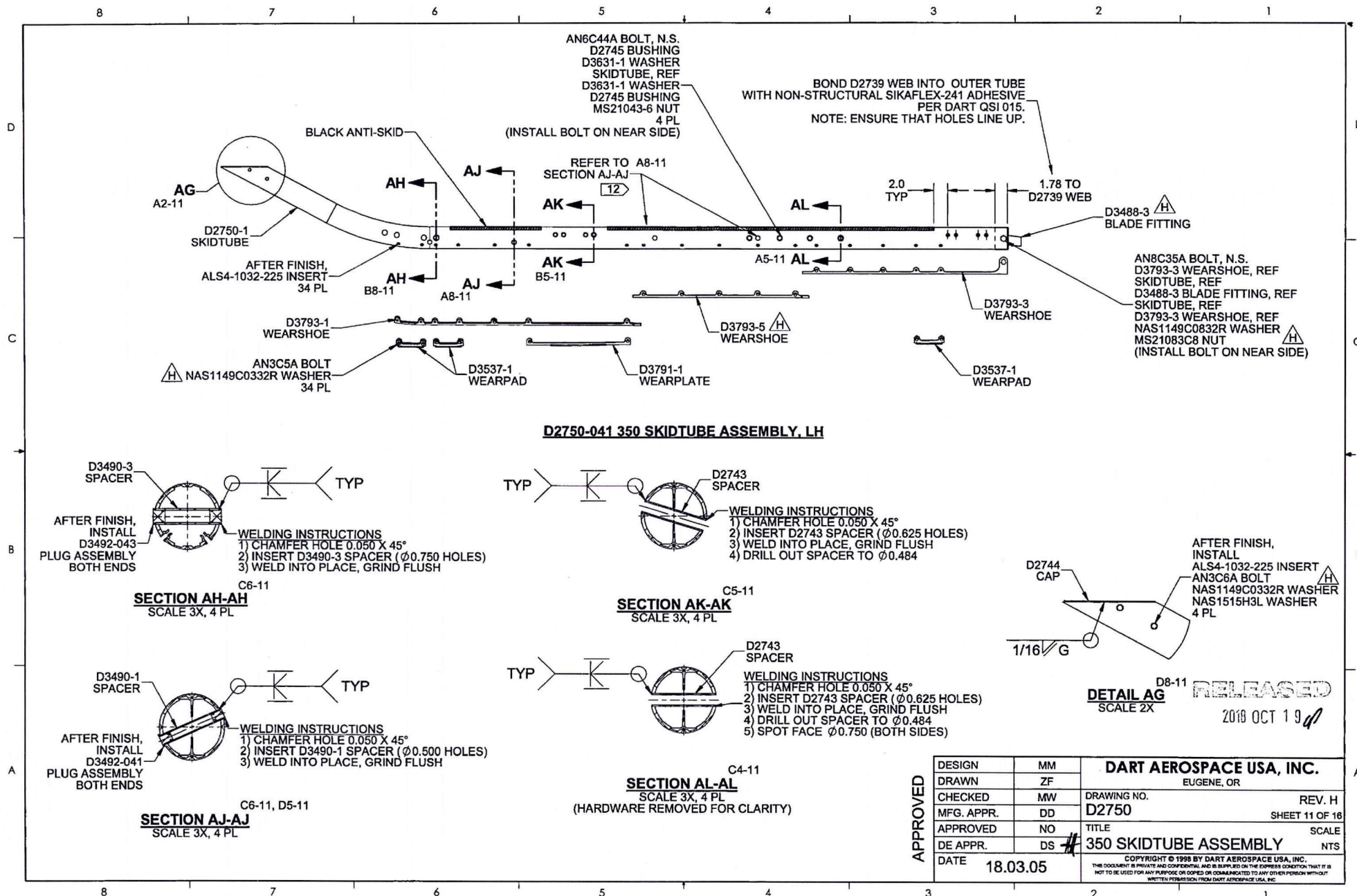


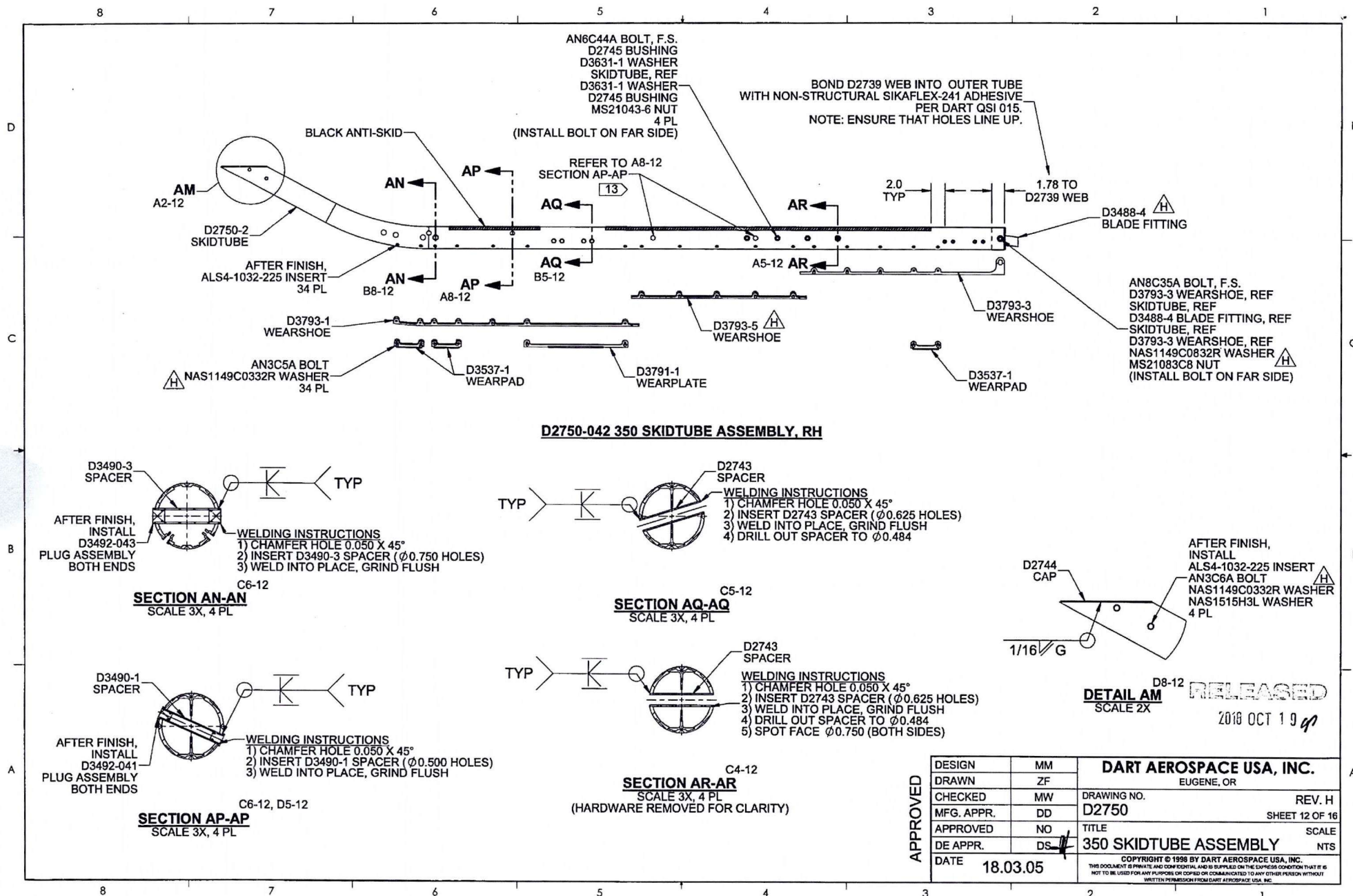
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TWIST ON FWD BEND
(VIEW LOOKING FWD)**

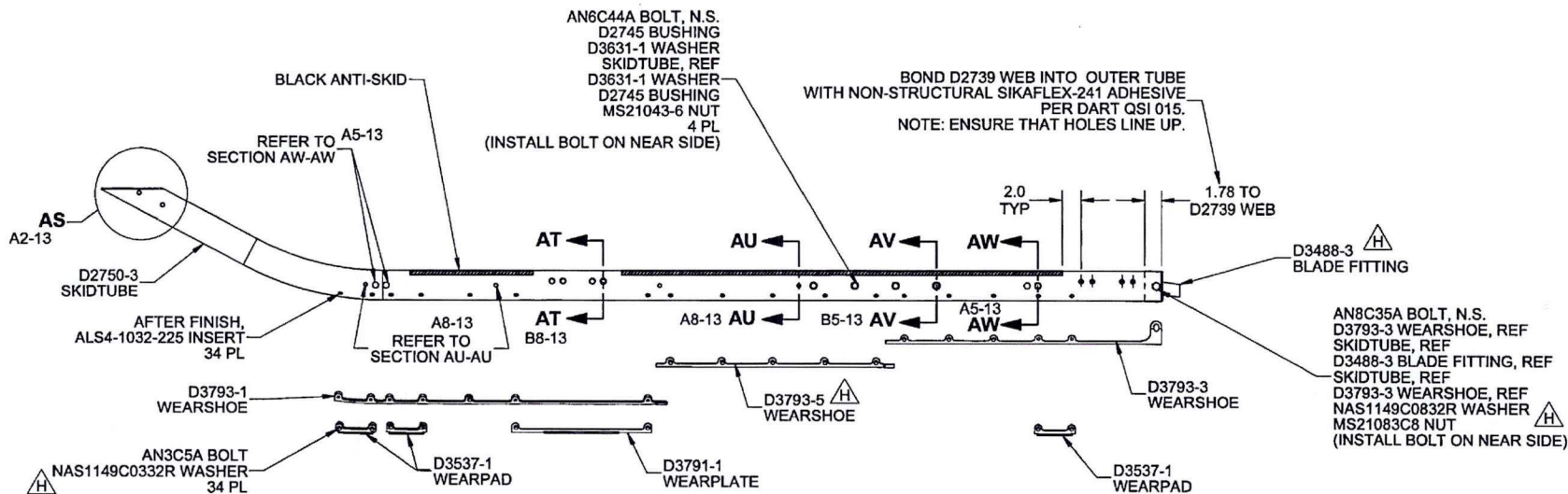


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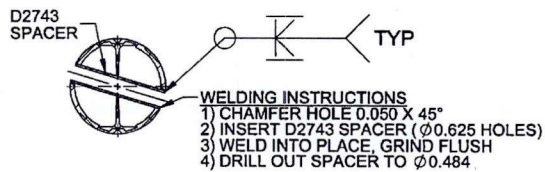
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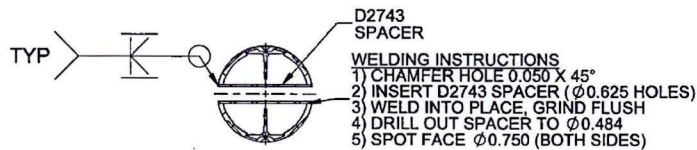




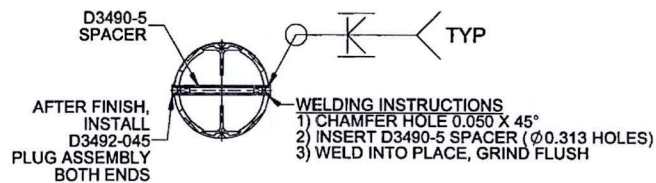
D2750-043 350 SKIDTUBE ASSEMBLY, LH



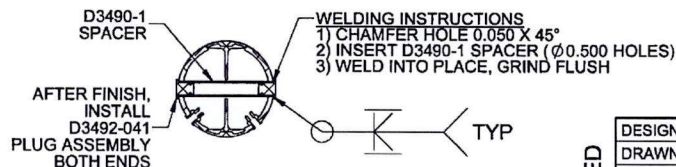
SECTION AT-AT
SCALE 3X, 4 PL



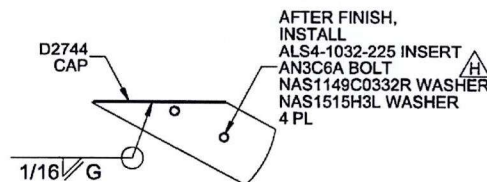
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



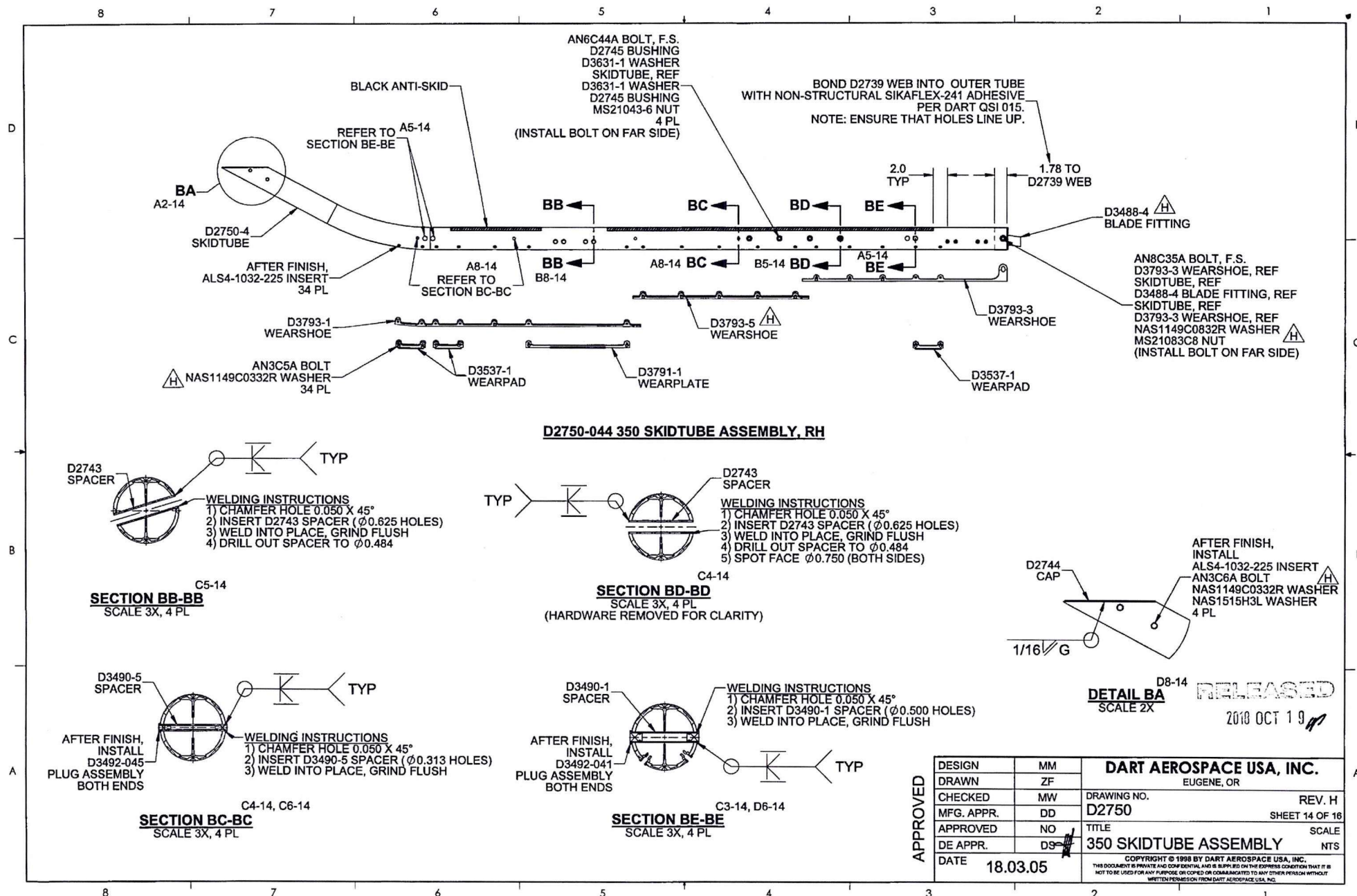
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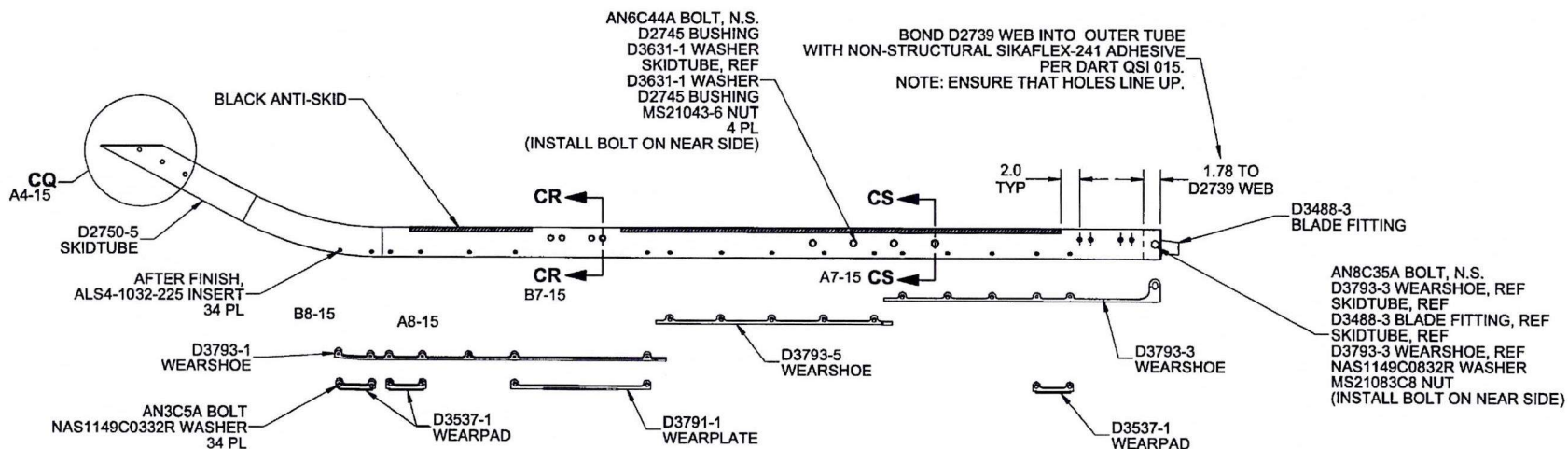


DETAIL AS
SCALE 2X

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	CHECKED	MW	DRAWING NO.	REV. H
	MFG. APPR.	DD	D2750	SHEET 13 OF 16
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
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2010 OCT 19

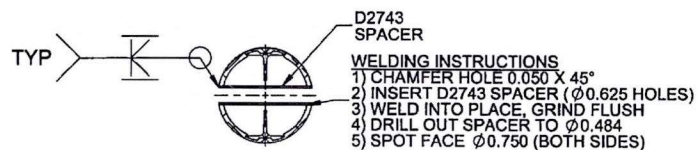




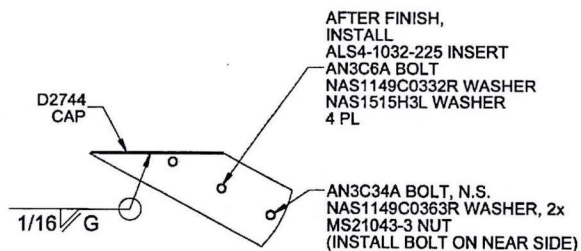
D2750-051 350 SKIDTUBE ASSEMBLY, LH



SECTION CR-CR SCALE 3X, 4 PL



SECTION CS-CS SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



DETAIL CQ SCALE 2X

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2018 OCT 1 9 42

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Part: D350-636-022

Job No: 193667

Serial No/Batch: S174137

Revision: H/K

Inspector:

Exp Date:

Instructions: FAA STC S4FC

CTC SHCJ - / Issue 4, LUNA VI